

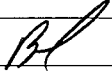


Work Order ID 53325




October 30, 2009 10:19:05 AM



Page 1

Item ID: D3443-043 Accept  Setup Start 
Revision ID: C Stop 
Item Name: Strut Weldment Assembly
Start Date: 30/10/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan:  Date: 09-10-30 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								
110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
120		0.00							
	✓ QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

CPL 09 11 09

PD 09.11.11 (5)

5  05-11-11

October 30, 2009 10:19:05 AM



00000000000000000000000000000000

Stop

**Cust Item ID:**

Customer:

Reference:

Run Start

[REDACTED]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

Abstract

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



Powdercoat

Memo

0.00

Powder Coating

1-Mask holes as per dwg D3443 ☐ START TIME: 7:00 ☐ OVEN TEMPERATURE: 400°F ☐ FINISH TIME: 7:30 am

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:_____

0.00



Packaging

Memo

0.00

Packaging

Work Order ID 53325

October 30, 2009 10:19:05 AM



Page 3

Item ID: D3443-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Strut Weldment Assembly

Start Date: 30/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/12 *[Signature]*
mk
09-11-12

Picklist Print

October 30, 2009 10:19:09 AM

Page 1

Work Order ID: 53325



Parent Item: D3443-043RevC



Parent Item Name: Strut Weldment Assembly

Start Date: 30/10/2009

Required Date: 13/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3443-3RevC

Manufactured

No

100

Each

10.0000

4.0000



Clevis

B48083 → ③ * Pl 09.11.10
B52984 → ② *

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

52984

10

10

D3443-7RevC

Manufactured

No

100

Each

0.0000

4.0000



Tubing

D3966-4-750RevA

Manufactured

No

100

Each

0.0000

4.0000



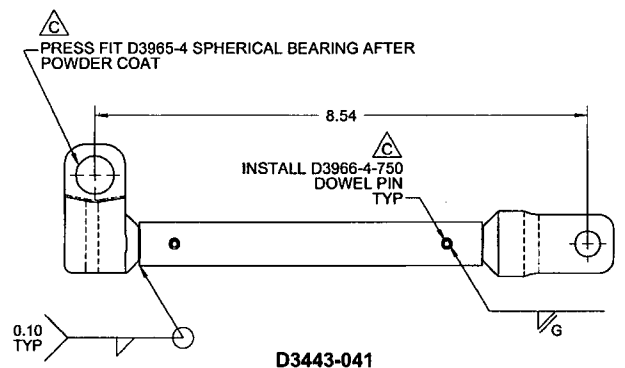
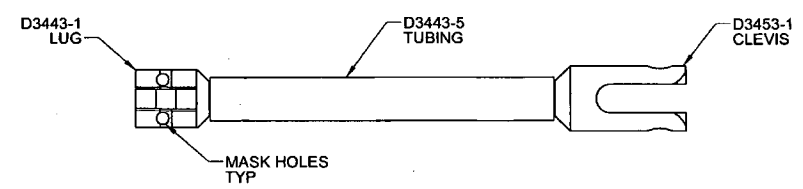
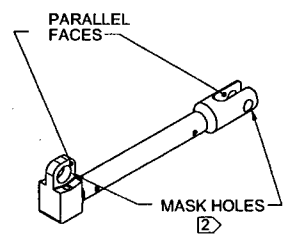
Pin, Dowel

B46560 → ⑤ * Pl 09.11.10
~~B52984~~ →
B53631 → ⑤ * Pl 09.11.10

PARTS NOT
SCANNED



8 7 6 5 4 3 2 1



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

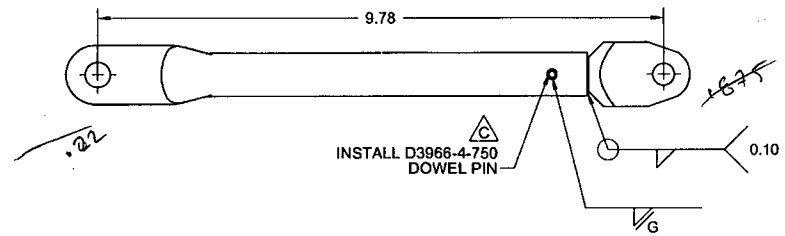
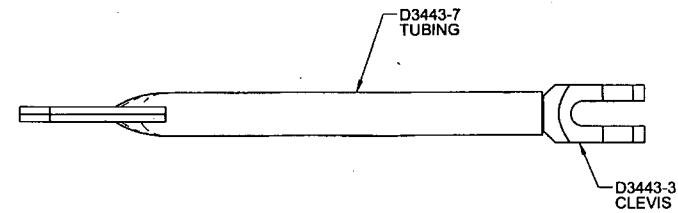
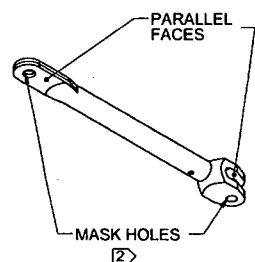
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WITHOUT
WORK ORDER
NO. 83325
BF 09/10-30

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09/10/25/11P

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2): 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3): 0.551 WAS 0.451 (ZN C1-3): R0.219 WAS R0.050 (ZN C4-3): D3965-4 WAS SPAENAU P/N (ZN C8-1, B5-2): D3966-4-750 WAS McMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED		D3443	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		STRUT WELDMENT ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.25		

8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

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WORK ORDER
NO. 53325

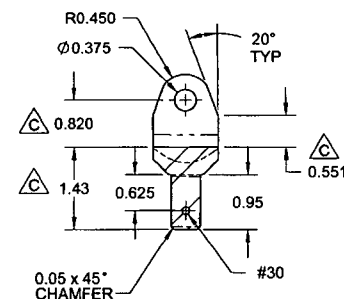
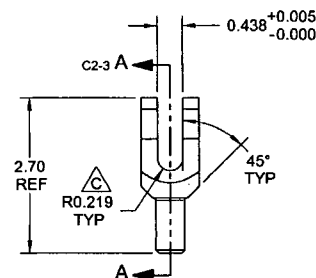
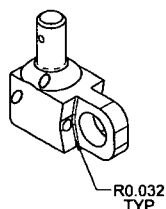
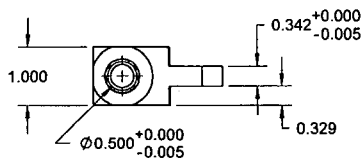
RELEASED
09/06/25/14

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs
 - 8) WELD PER DART QSI 004

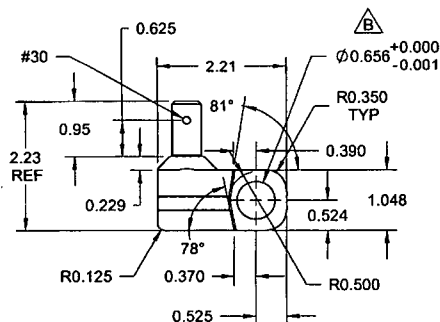
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY NTS	
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8 7 6 5 4 3 2 1

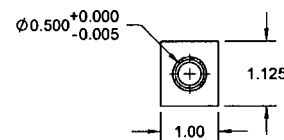
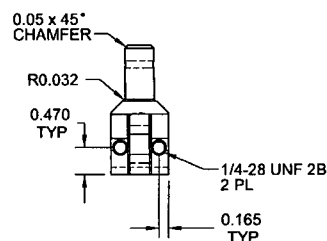
8 7 6 5 4 3 2 1



SECTION A-A C4-3



D3443-1 LUG






D3443-3 CLEVIS

NOTES:

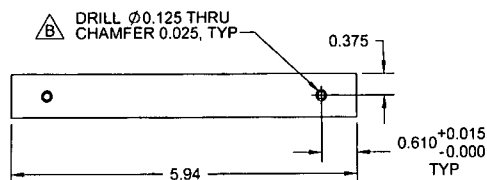
- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

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WITHOUT NOTICE
WORK ORDER
NO. 53825

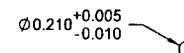
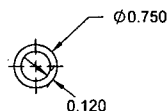
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09/08/25/14

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
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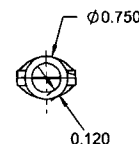
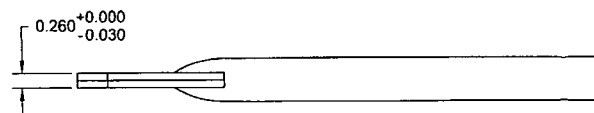


D3443-5 TUBING



D3443-9 PIN

- D3443-9 NOTES:**
 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: N/A



D3443-7 TUBING

- D3443-5/7 NOTES:**
 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: D3443-5 = 0.41 lbs
 D3443-7 = 0.62 lbs

SHOWN
 REF. 1
 ENGINEER
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 SUBJECT TO
 WITHOUT
 WORK
 NO. 53325

RELEASED
 01/08/25

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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